

Date: Monday, 7/30/2007 1:54:15 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 33801					
Estimate Number	: 12782					
P.O. Number	:		Part Number	: D35643		
This Issue	: 7/30/2007	S.O. No. :	Drawing Number	: D3564 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: C		
Previous Run	: 33244		Material	:		
Written By	:	<i>HB</i>	Due Date	: 8/28/2007	Qty:	12 Um: Each
Checked & Approved By	<i>HB 07-07-30</i>					
Comment	Est Rev:A	New Issue 07-03-08 ec				
	Est Rev:B	As per Rev C 07-07-09 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.9177 sf(s)/Unit Total : 11.0124 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <i>M304S16GA HB 07-07-31</i>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <i>C</i> <i>HB 07-07-31</i> <span style="margin-left: 100px;">(B)</span> Prog Rev: <i>C</i> <i>HB 07-07-31</i> <span style="margin-left: 100px;">07/08/01</span>	
		2-Deburr if necessary	<span style="margin-left: 100px;">(13)</span>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>HB 07-07-31</i>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>QC8 07-08-01</i> <span style="margin-left: 100px;">(N3)</span>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157	<i>FF 07-08-08</i> <span style="margin-left: 100px;">13</span> <i>FF 07-08-08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:15 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33801

Part Number: D35643

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



ES  
07/08/07 13



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M105138

FC

07/08/14

13

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/14

13

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/14

13

10.0 POWDER COATING POWDER COATING



M 104846

BR/M

07-08-15

13

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/08/15

13X

12.0 PACKAGING 1 PACKAGING RESOURCE #1



13X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP 18

m-k 07/08/15

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



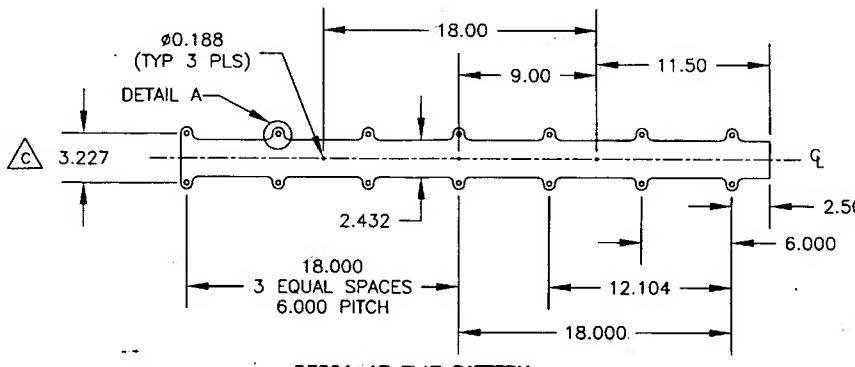
U 07-08-16

W/O:		WORK ORDER CHANGES					
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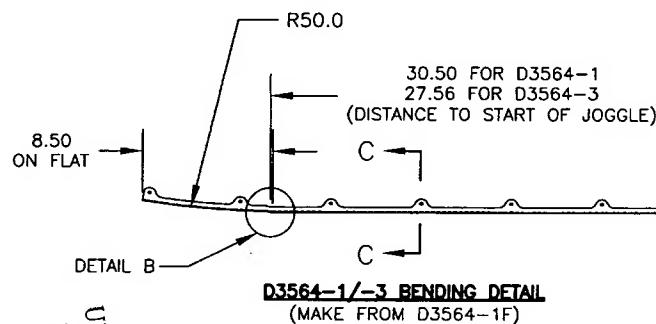
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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

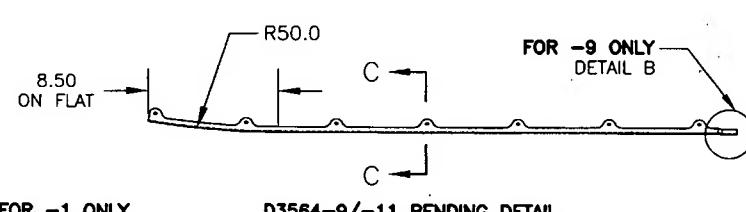
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

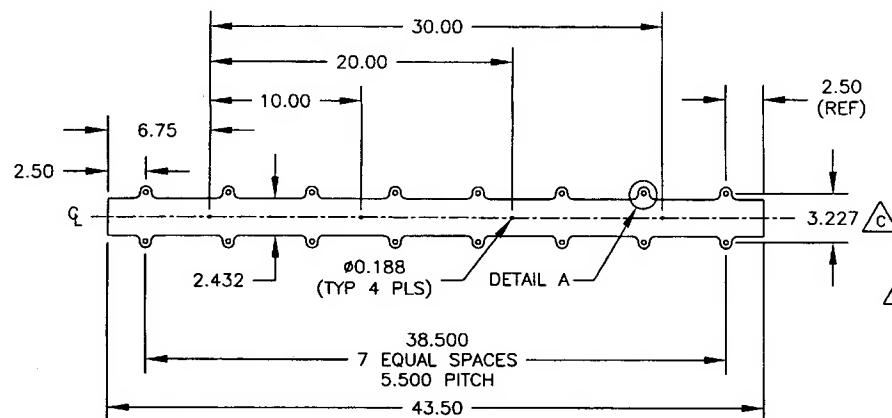
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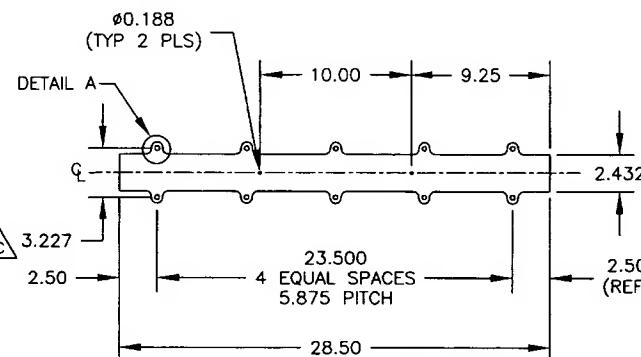
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
<i>PSL</i>	<i>PH</i>	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
CHECKED <i>PSL</i>	APPROVED <i>PH</i>	DRAWING NO. D3564 REV. C
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:8

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WORK ORDER  
NO 23801

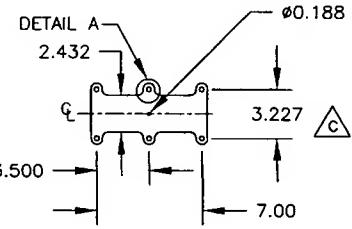
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07.06.28 *PH*



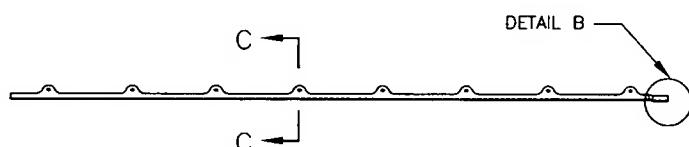
**D3564-5F FLAT PATTERN**



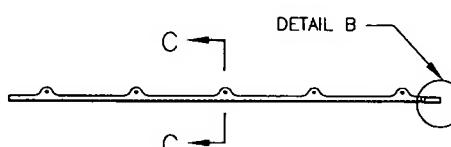
**D3564-7F FLAT PATTERN**



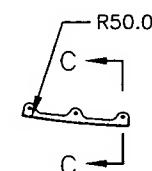
**D3564-13F FLAT PATTERN**



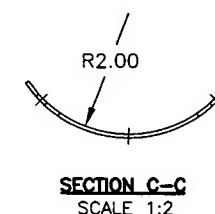
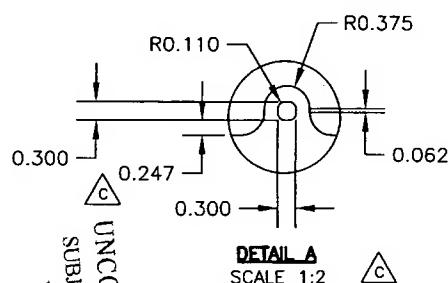
D3564-5 BENDING DETAIL  
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL  
(MAKE D3564-7 FROM D3564-7F)



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**SECTION C-1**

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07.06.2014

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NO. 33801

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DESIGN

CHECKED

10 of 10

**DART AEROSPACE LTD.**

Mr. C. A. M.

Sheet 2 of 2

10

1:8

DART AEROSPACE LTD	Work Order:	33801
Description: WEAR PAD	Part Number:	D 3564-3
Inspection Dwg:	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BB</u>	Audited by: <u>EP</u>	Prototype Approval: <u>W/A</u>
Date: <u>07-07-31</u>	Date: <u>07/08/01</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

